



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2572

Job Sheet 172063



Part No: D2572

Job Qty: 12 ea

Part Name: Saddle, Fwd, In



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/12/18

Job Tracking No:

Due Date: 2/19/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	2/16/18	2/16/18	0.00	0.00	Start Up Machining		
100	CNC Vertical Machining	12 pcs	2/17/18	2/17/18	0.62	19.35	HAAS 1		
110	Mill Conv	12 pcs	2/17/18	2/17/18	0.00	2.00	Mill Conv 1		
120	QC	12 pcs	2/17/18	2/17/18	0.00	0.00	QC2		
130	QC	12 pcs	2/17/18	2/17/18	0.00	0.00	QC8		
140	HandFinish	12 pcs	2/17/18	2/17/18	0.00	0.49	HandFinish1		
150	Powdercoat	12 pcs	2/19/18	2/19/18	0.00	0.46	Powdercoat1		
160	QC	12 pcs	2/19/18	2/19/18	0.00	0.00	QC3		
170	Packaging	12 pcs	2/19/18	2/19/18	0.00	0.00	Packaging3		
180	QC21-SA	12 Ea	2/19/18	2/19/18	0.00	0.00	QC21		

Part Op 100 - Program Batch No. _____ Double check by: _____ 1-Machine Step No 1 per Folio FA051 and inspect per
Descriptions: attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp
110 - Machine keyway as per dwg D2571 & D2572
150 - START TIME: 2:30 PM FINISH TIME: 8:00 PM

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	12 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-005	12	65	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Fwd Inboard	7.990Inches + 0.020 - 0.000	8.010 7.990		

Plex 2/12/18 12:55 PM Dart.Gagnon.Michelle



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S045109



Part: D2572

Job No: 172063

Serial No/Batch: S045109

Revision: D2572

Inspector:

Date: 02/25/18

6	Saddle, Fwd Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Fwd Inboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Fwd Inboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Fwd Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Fwd Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Fwd Inboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Inboard	1.490Inches	+ 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Inboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Inboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Inboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Fwd Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Inboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

Plex 2/12/18 12:55 PM Dart.Gagnon.Michelle

DART AEROSPACE LTD	Work Order: 172 063
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438	VLR	18/03/11
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	7.999	7.999	7.999		
F	0.490	0.510		.500	.500	.497	.499		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.875	3.875	3.875		
P	0.115	0.135		.130	.128	.130	.126		
Q	0.115	0.135		.125	.125	.125	.126		
R	0.240	0.260		.254	.254	.253	.253		
S	0.115	0.135		.128	.127	.127	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	.241	.242	.241		
W	0.115	0.135		.127	.127	.125	.126		
X	0.307	0.312		.311	.311	.310	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.362	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.066	.066	.070	.070		
AD	0.240	0.260		.252	.251	.252	.251		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.128	.127	.123	.128		
AG	0.240	0.280		.245	.245	.245	.248		
AH	0.240	0.260		.253	.250	.250	.251		
AI	2.000	2.020		2.000	2.000	2.000	2.00		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: SBL
Date: 18/02/27

Audited by: [Signature]
Date: 18/03/02

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 172 063
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	# 5	# 6	# 7	# 8		
A	0.438	0.443		.438	.438	.438	.438	VHJ	18/03/1
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.00		
F	0.490	0.510		.498	.503	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.556	0.578		.568	.568	.568	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.130	.132	.130	.130		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.253	.253	.253	.253		
S	0.115	0.135		.127	.126	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	.240	.241	.242		
W	0.115	0.135		.126	.127	.126	.125		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.070	.065	.070	.069		
AD	0.240	0.260		.252	.251	.251	.252		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.122	.123	.130	.130		
AG	0.240	0.260		.247	.253	.248	.250		
AH	0.240	0.260		.252	.250	.252	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: SBZ
Date: 18/02/28

Audited by: [Signature]
Date: 18/03/02

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.13	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 172 063
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#9	#10	#11	#12		
A	0.438	0.443		.438	.438	.438	.438	11/18/03/01	
B	1.748	1.755		1.750	1.747	1.748	1.748		
C	3.495	3.505		3.500	3.497	3.498	3.498		
D	1.748	1.755		1.750	1.747	1.748	1.748		
E	7.990	8.010		8.000	7.998	8.000	8.000		
F	0.490	0.510		.500	0.498	.500	0.501		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.500	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.568	0.578		.569	.569	.569	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.500	2.510		2.500	2.500	2.500	2.500		
O	3.874	3.879		3.874	3.874	3.874	3.874		
P	0.135	0.135		.133	.129	.133	0.1315		
Q	0.135	0.135		.125	.126	.125	0.130		
R	0.240	0.260		.253	.253	.252	.152		
S	0.135	0.135		.126	.126	.125	.132		
T	0.178	0.196		.188	.188	.188	.188		
U	2.940	2.960		2.960	2.960	2.960	1.960		
V	0.230	0.250		.239	.240	.240	.24		
W	0.135	0.135		.122	0.132	0.133	.132		
X	0.307	0.312		.311	.312	0.312	0.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.362	0.372		.363	.363	.363	0.363		
AA	0.470	0.500		.500	.500	.500	0.500		
AB	0.618	0.635		.625	.624	.624	0.624		
AC	0.063	0.063		.065	.070	.060	0.060		
AD	0.250	0.260		.250	.252	.250	.250		
AE	1.385	1.395		1.385	1.385	1.385	1.385		
AF	0.135	0.135		.132	.123	.133	.125		
AG	0.250	0.255		.250	.252	.253	.253		
AH	0.250	0.260		.250	.250	.249	.250		
AI	2.000	2.010		2.000	2.000	2.000	2.000		
AJ	0.025	0.045		.033	0.033	0.033	0.33		

Accept/Reject

Measured by: SBL
Date: 18/02/28

Audited by: [Signature]
Date: 18/03/02

Rev	Date	Change	Revised by	Approved
B	02/09/24	Re-format; Added Rev. D	KJ	
C	02/10/11	Re-format; Added DT8682, DT8683, DT8634	KJ	
D	05/05/06	Added dimension AI	KJ/RF	
E	05/12/05	Added dimension AJ	KJ/JLM	
F	18/13/01	Dwg Rev updated	KJ	